

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ **PAR #:** _____ **Fault Category:** _____ **NCR: Yes No** **DQA:** _____ **Date:** _____
Resolution: _____ **Disposition:** _____ **QA: N/C Closed:** _____ **Date:** _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

78211

January-02-12 10:16:07 AM

N900040100

Setup Start *NS1*

Stop ***NS2***

12

12

Reference:

Run Start *NR1*

Stop ***NR2***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

120	QC5- Inspect part completeness to step on W/O	0.00
-----	---	------

0.00

0.00

Ensure 90 deg angle is within tol. (+/-0.5deg) critical dim.

0.00

0.00

Perforator

1- Drill as per dwg D3463(One side only)
2-Deburr as per dwg D3463

0.00

0.00

Memo

Quality Control

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Work Order ID 78211

78211

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January-02-12 10:16:07 AM

Item ID: D3463-1 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Arm
 Start Date: 02/01/2012 Start Qty: 12.00 ***12*** Cust Item ID:
 Required Date: 31/01/2012 Req'd Qty: 12.00 ***12*** Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
150	QC8- Inspect parts - second check	0.00							
150									
QC	Memo	0.00	22	2.2.8		12	1		
Quality Control									
160	Identify as per dwg & Stock Location: <i>W/A</i>	0.00							
160									
Packaging	Memo	0.00							
Packaging									
170	QC21- Final Inspection - Work Order Release	0.00							
170									
QC	Memo	0.00							
Quality Control									

M.C.J
12/02/09
(12)

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Picklist Print

January-02-12 10:16:11 AM

Page 1

Work Order ID: 78211

78211

Parent Item: D3463-1

D3463-1

Parent Item Name: Arm

Start Date: 02/01/2012

Required Date: 31/01/2012

Start Qty: 12.00

Required Qty: 12.00

Comments:

IPP REV. A 05.11.17 NEW ISSUE EC
ADDED MANUAL LATHE STEP 10-06-02 JLM VER:DD

IPP REV:B

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M316TR1.00W.120		Purchased		No		100	f	17.3750	2.083	26.31158			

M316TR1 00W 120

316 RD tubing 1.00 x .120w

Location

Loc Qty

Loc Code

MAT018

13.6125

118390

13.6125

MAT037

3.7625

111096

1.3125

117890

2.45

M120183

26.5 ~~20~~ 12/04/18

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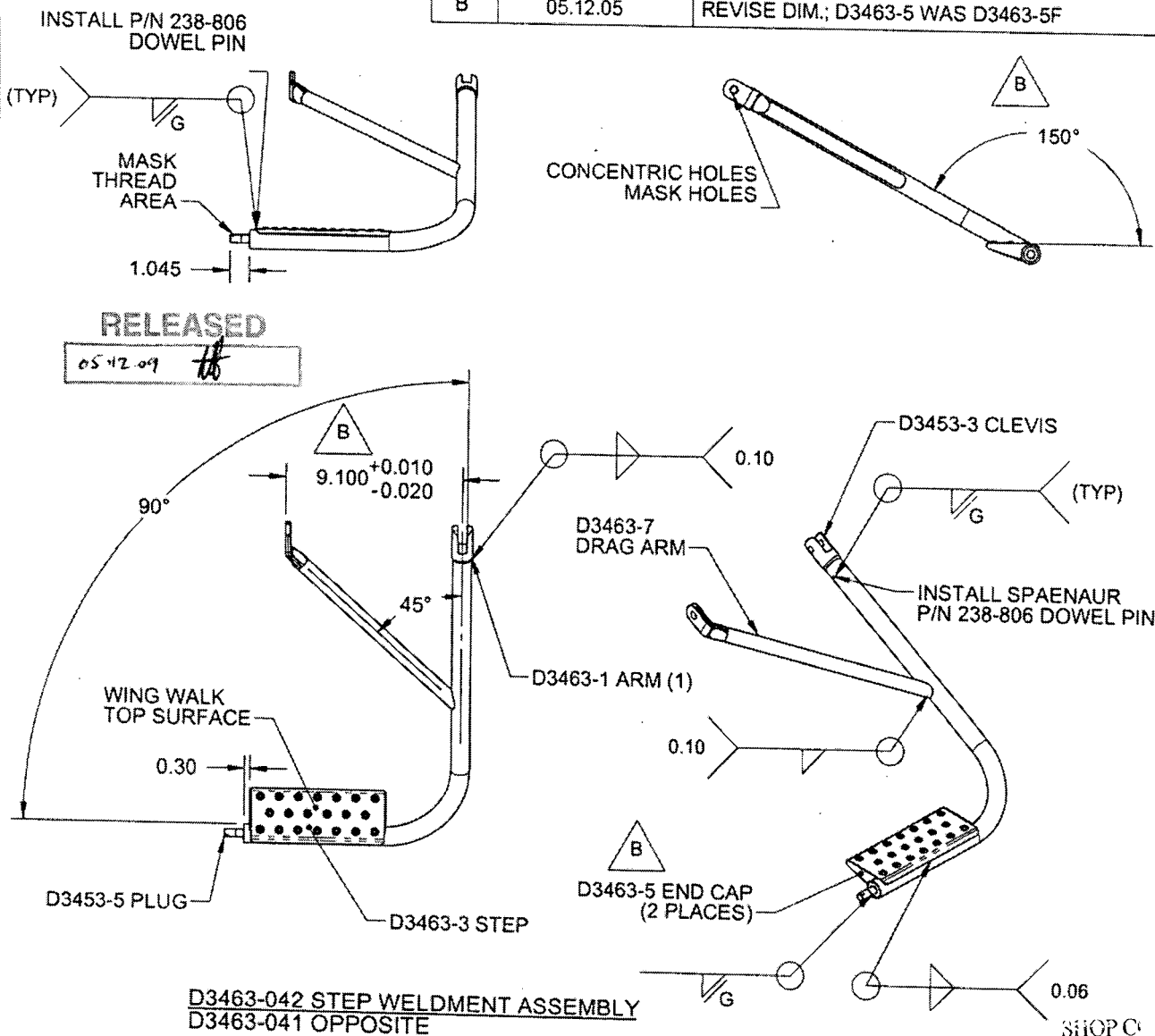
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DESIGN RF	DRAWN BY RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED #	APPROVED #	DRAWING NO. D3463	REV. B SHEET 1 OF 4
DATE 05.12.05		TITLE STEP WELDMENT	SCALE 1:8
A	05.09.20	NEW ISSUE	
B	05.12.05	REVISE DIM.; D3463-5 WAS D3463-5F	



D3463-042 STEP WELDMENT ASSEMBLY
D3463-041 OPPOSITE

NOTES:

- 1) WELD PER DART QSI 004
- 2) FINISH: POWDER COAT WHITE (4.3.5.2) PER DART QSI 005 4.3
BLACK ANTI-SKID PAINT PER DART QSI 005 4.4
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL UNMARKED SHARP EDGES 0.005 TO 0.010
- 6) IDENTIFY WITH DART P/N USING FINE POINT PERMANENT INK MARKER

SHOP COPY
RETURN TO
ENGINEER
UNCONTROLLED COPY
SUBJECT TO REVISION
WITHOUT NOTICE
WORK ORDER
NO. 78211

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M.C.J
12/01/02

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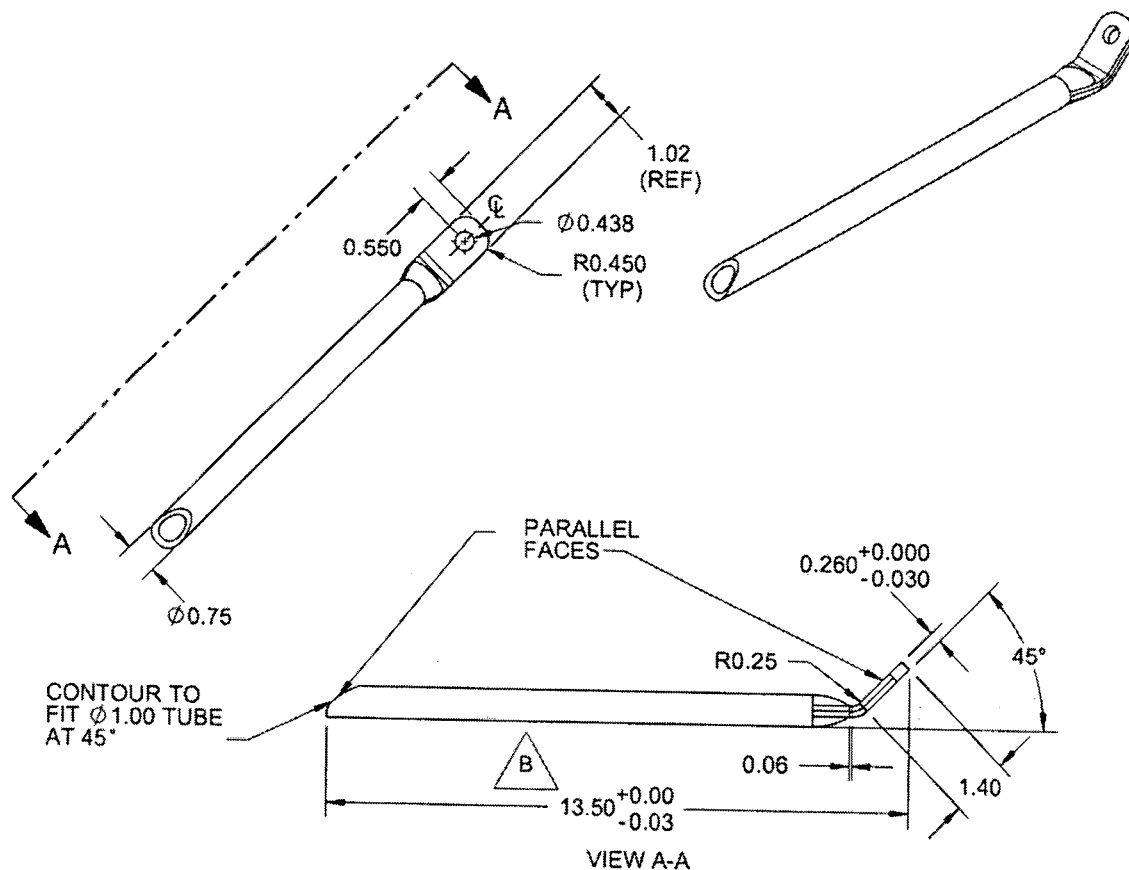


78211

DESIGN RF	DRAWN BY RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED #	APPROVED #	DRAWING NO. D3463	REV. B
DATE 05.12.05		TITLE STEP WELDMENT	SHEET 3 OF 4
			SCALE 1:4

RELEASED

05.12.04 #



D3463-7 DRAG ARM

NOTES:

- 1) MATERIAL: AISI 316/304 SS SEAMLESS TUBING (REF. DART SPEC. M304TR0.750W.120)
- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL UNMARKED SHARP EDGES 0.005 TO 0.010

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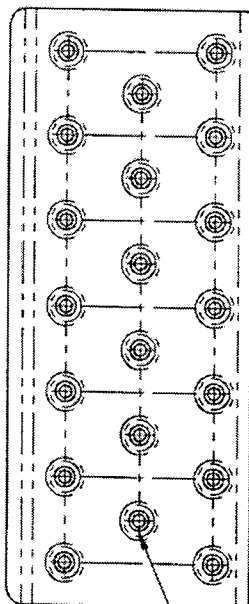
NOTE: Date & initial all entries



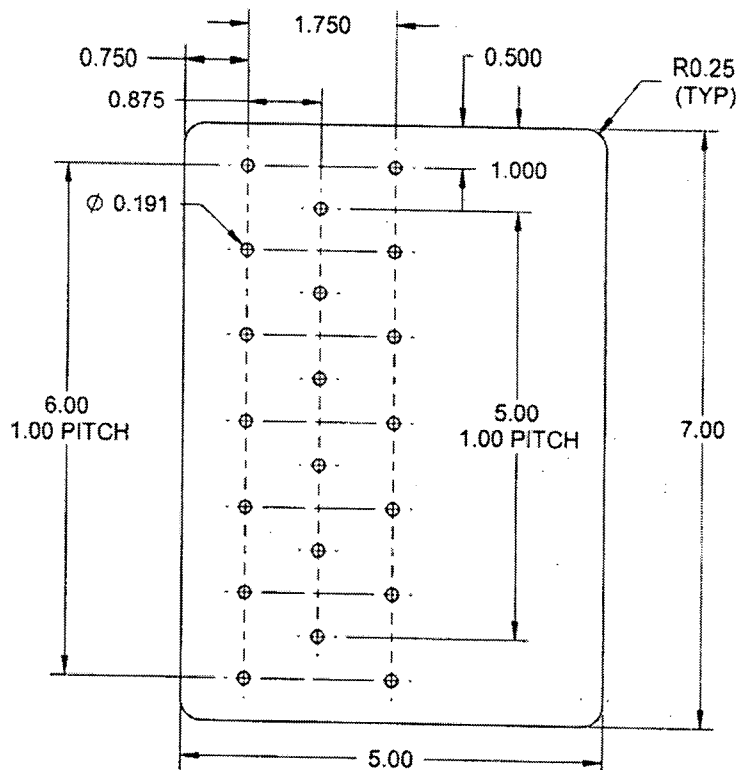
DESIGN RF	DRAWN BY RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED #	APPROVED #	DRAWING NO. D3463	REV. B SHEET 4 OF 4
DATE 05.12.05	TITLE STEP WELDMENT		SCALE 1:2

RELEASED

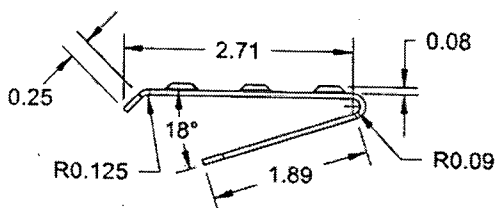
05.12.05 #



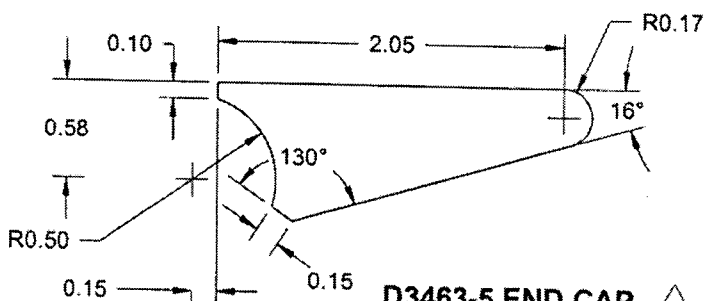
FORM USING
D3463-3T1



D3463-3F FLAT PATTERN



D3463-3 STEP



D3463-5 END CAP
SCALE 1:1



NOTES:

- 1) MATERIAL: AISI 304/316 SS SHEET, 0.060 THICK (REF. DART SPEC. M304S16GA)
- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
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